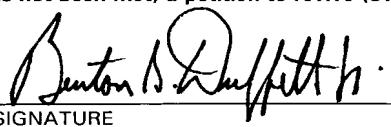


FORM-PTO-1390 (Rev. 9-2001)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE		ATTORNEY'S DOCKET NUMBER
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371/				009760-015
INTERNATIONAL APPLICATION NO. PCT/JP00/04671		INTERNATIONAL FILING DATE 12 July 2000	U.S. APPLICATION NO. (If known, see 37 CFR 1.5) Unassigned 10/031066	
TITLE OF INVENTION THERMOPLASTIC RESIN COMPOSITION AND MOLDED ARTICLE THEREOF		PRIORITY DATE CLAIMED 16 July 1999		
APPLICANT(S) FOR DO/EO/US KEIICHI KANAKA, TOSHIRO SHIWAKU, and MINEO OHTAKE				
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:				
<ol style="list-style-type: none"> <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371. <input checked="" type="checkbox"/> This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (21) indicated below. <input type="checkbox"/> The US has been elected by the expiration of 19 months from the priority date (Article 31). <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2)) <ol style="list-style-type: none"> <input checked="" type="checkbox"/> is attached hereto (required only if not communicated by the International Bureau). <input checked="" type="checkbox"/> has been communicated by the International Bureau. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US). <input checked="" type="checkbox"/> An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)) <ol style="list-style-type: none"> <input checked="" type="checkbox"/> is attached hereto. <input type="checkbox"/> has been previously submitted under 35 U.S.C. 154(d)(4). <input checked="" type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3)) <ol style="list-style-type: none"> <input type="checkbox"/> are attached hereto (required only if not communicated by the International Bureau). <input type="checkbox"/> have been communicated by the International Bureau. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired. <input checked="" type="checkbox"/> have not been made and will not be made. <input type="checkbox"/> An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)). <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)). <input type="checkbox"/> An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)). 				
Items 11 to 20 below concern document(s) or information included:				
<ol style="list-style-type: none"> <input checked="" type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98. <input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. <input checked="" type="checkbox"/> A FIRST preliminary amendment. <input type="checkbox"/> A SECOND or SUBSEQUENT preliminary amendment. <input type="checkbox"/> A substitute specification. <input type="checkbox"/> A change of power of attorney and/or address letter. <input type="checkbox"/> A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825. <input type="checkbox"/> A second copy of the published international application under 35 U.S.C. 154(d)(4). <input type="checkbox"/> A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4). <input checked="" type="checkbox"/> Other items or information: 				
A certified copy of Japanese Patent Application 11-202839, filed 16 July 1999, was submitted during the international phase of the examination. Thus the claim for priority has been perfected.				



21839

U.S. APPLICATION NO. (If known, see 37 CFR. 1.65) PCT/JPO0/04671	INTERNATIONAL APPLICATION NO. PCT/JPO0/04671	ATTORNEY'S DOCKET NUMBER 009760-015
21. <input checked="" type="checkbox"/> The following fees are submitted:	CALCULATIONS	PTO USE ONLY
Basic National Fee (37 CFR 1.492(a)(1)-(5)):		
Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to U.S. PATENT AND TRADEMARK OFFICE and International Search Report not prepared by the EPO or JPO \$1,040.00 (960)		
International preliminary examination fee (37 CFR 1.482) not paid to U.S. PATENT AND TRADEMARK OFFICE but International Search Report prepared by the EPO or JPO \$890.00 (970)		
International preliminary examination fee (37 CFR 1.482) not paid to U.S. PATENT AND TRADEMARK OFFICE but international search fee (37 CFR 1.445(a)(2)) paid to U.S. PATENT AND TRADEMARK OFFICE \$740.00 (958)		
International preliminary examination fee (37 CFR 1.482) paid to U.S. PATENT AND TRADEMARK OFFICE but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$710.00 (956)		
International preliminary examination fee (37 CFR 1.482) paid to U.S. PATENT AND TRADEMARK OFFICE and all claims satisfied provisions of PCT Article 33(1)-(4) \$100.00 (962)		
ENTER APPROPRIATE BASIC FEE AMOUNT = \$ 1,040.00		
Surcharge of \$130.00 (154) for furnishing the oath or declaration later than months from the earliest claimed priority date (37 CFR 1.492(e)). 20 <input type="checkbox"/> 30 <input type="checkbox"/>		
Claims	Number Filed	Number Extra
Total Claims	20 -20 =	0
Independent Claims	1 -3 =	0
Multiple dependent claim(s) (if applicable)		+\$280.00 (968)
TOTAL OF ABOVE CALCULATIONS = \$ 1,040.00		
Reduction for ½ for filing by small entity, if applicable (see below). + \$ --		
SUBTOTAL = \$ 1,040.00		
Processing fee of \$130.00 (156) for furnishing the English translation later than months from the earliest claimed priority date (37 CFR 1.492(f)). 20 <input type="checkbox"/> 30 <input type="checkbox"/>		
+		
TOTAL NATIONAL FEE = \$ 1,040.00		
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 (581) per property + \$ 40.00		
TOTAL FEES ENCLOSED = \$ 1,080.00		
		Amount to be refunded: \$
		charged: \$
a. <input type="checkbox"/> Small entity status is hereby claimed.		
b. <input checked="" type="checkbox"/> A check in the amount of \$ 1,080.00 to cover the above fees is enclosed.		
c. <input type="checkbox"/> Please charge my Deposit Account No. 02-4800 in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.		
d. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 02-4800. A duplicate copy of this sheet is enclosed.		
NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.		
SEND ALL CORRESPONDENCE TO:		
Benton S. Duffett, Jr. BURNS, DOANE, SWECKER & MATHIS, L.L.P. P.O. Box 1404 Alexandria, Virginia 22313-1404 (703) 836-6620		
SIGNATURE  Benton S. Duffett, Jr. NAME		January 15, 2002 DATE
22,030 REGISTRATION NUMBER		

10/031066
531 Rec'd PCT/I 15 JAN 2002

Patent
Attorney's Docket No. 009760-015

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Patent Application of)
KEIICHI KANAKA et al.) BOX PCT
Application No.: (Unassigned)) Attention: DO/EO/US
Filed: January 15, 2002) Group Art Unit: (Unassigned)
For: THERMOPLASTIC RESIN) Examiner: (Unassigned)
COMPOSITION AND MOLDED)
ARTICLE THEREOF)

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents
Washington, D.C. 20231

Sir:

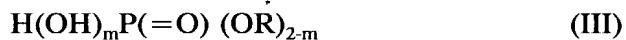
This is a national phase filing of International Application No. PCT/JP00/04671,
filed July 12, 2000.

Please amend the Application as follows:

IN THE CLAIMS:

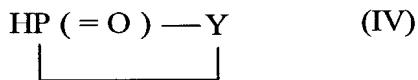
Kindly replace Claims 6 to 11 as follows:

6. (Amended) The composition according to claim 1, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



wherein m is 0 or 1 and R is a monovalent organic group.

7. (Amended) The Composition according to claim 1, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (IV):



wherein Y is a divalent α , ω -dioxy organic group.

8. (Amended) The composition according to claim 1, which further contains a thermoplastic resin not forming an anisotropic molten phase, except for (A) and (B), in an amount of 1 to 90 parts by weight to 100 parts by weight of the total amount of (A) and (B).

9. (Amended) The composition according to claim 1, which further contains in inorganic filler in an amount of 1 to 100 parts by weight to 100 parts by weight of the total amount of (A) and (B).

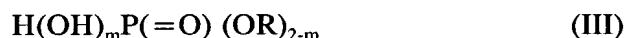
10. (Amended) A molded article prepared by molding the composition according to claim 1:

11. (Amended) An injection molded article, wherein the liquid crystal polymer (B) capable of forming an anisotropic molten phase is present in the state of fibers having

an average aspect ratio of 5 or more in a matrix of the thermoplastic polyester resin (A) not forming an anisotropic molten phase as a result of an injection molding of the composition according to claim 1.

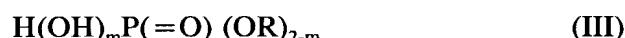
Kindly add the following new Claims 12 to 20:

12. (New) The composition according to claim 2, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



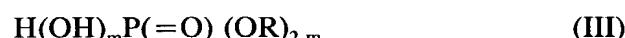
wherein m is 0 or 1 and R is a monovalent organic group.

13. (New) The composition according to claim 3, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



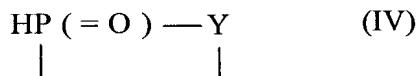
wherein m is 0 or 1 and R is a monovalent organic group.

14. (New) The composition according to claim 4, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



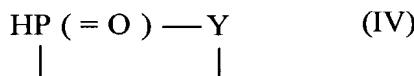
wherein m is 0 or 1 and R is a monovalent organic group.

15. (New) The Composition according to claim 2, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (IV):



wherein Y is a divalent α , ω -dioxy organic group.

16. (New) The Composition according to claim 3, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (IV):



wherein Y is a divalent α , ω -dioxy organic group.

17. (New) The composition according to claim 2, which further contains a thermoplastic resin not forming an anisotropic molten phase, except for (A) and (B), in an amount of 1 to 90 parts by weight to 100 parts by weight of the total amount of (A) and (B).

18. (New) The composition according to claim 2, which further contains in inorganic filler in an amount of 1 to 100 parts by weight to 100 parts by weight of the total amount of (A) and (B).

19. (New) A molded article prepared by molding the composition according to claim 2.

20. (New) An injection molded article, wherein the liquid crystal polymer (B) capable of forming an anisotropic molten phase is present in the state of fibers having an average aspect ratio of 5 or more in a matrix of the thermoplastic polyester resin (A) not forming an anisotropic molten phase as a result of an injection molding of the composition according to claim 2.

Application No. (Unassigned)
Attorney's Docket No. 009760-15
Page 6

REMARKS

The present Amendment modifies the claim format only so as to eliminate the use of multiple dependence.

An Information Disclosure Statement is being filed concurrently herewith.

The examination and allowance of the Application are respectfully requested.

Respectfully submitted,

BURNS, DOANE, SWECKER & MATHIS, L.L.P.

By: Benton S. Duffett, Jr.

Benton S. Duffett, Jr.
Registration No. 22,030

P.O. Box 1404
Alexandria, Virginia 22313-1404
(703) 836-6620

Date: January 15, 2002

107051066

531 Rec'd PCT/PTC 15 JAN 2002

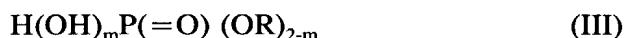
Application No. (Unassigned)

Attorney's Docket No. 009760-15

Mark-up of Claims - Page 1 of 1

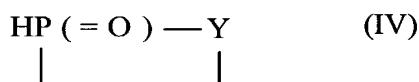
Attachment to Preliminary Amendment dated January 15, 2002
Mark-Up of Claims 6, 7, 8, 9, 10 and 11

6. (Amended) The composition according to [any of claims 1 to 4] claim 1, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



wherein m is 0 or 1 and R is a monovalent organic group.

7. (Amended) The Composition according to [any of claims 1 to 5] claim 1, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (IV):



wherein Y is a divalent α , ω -dioxy organic group.

8. (Amended) The composition according to [any of claims 1 to 7] claim 1, which further contains a thermoplastic resin not forming an anisotropic molten phase, except for (A) and (B), in an amount of 1 to 90 parts by weight to 100 parts by weight of the total amount of (A) and (B).

Application No. (Unassigned)
Attorney's Docket No. 009760-15
Mark-up of Claims - Page 2 of 2

Attachment to Preliminary Amendment dated January 15, 2002
Mark-Up of Claims 6, 7, 8, 9, 10 and 11

9. (Amended) The composition according to [any of claims 1 to 8] claim 1, which further contains in inorganic filler in an amount of 1 to 100 parts by weight to 100 parts by weight of the total amount of (A) and (B).

10. (Amended) A molded article prepared by molding the composition according to [any of claims 1 to 9] claim 1:

11. (Amended) An injection molded article, wherein the liquid crystal polymer (B) capable of forming an anisotropic molten phase is present in the state of fibers having an average aspect ratio of 5 or more in a matrix of the thermoplastic polyester resin (A) not forming an anisotropic molten phase as a result of an injection molding of the composition according to [any of claims 1 to 9] claim 1.

10/031066

531 Rec'd PC

15 JAN 2002

Description

THERMOPLASTIC RESIN COMPOSITION

AND MOLDED ARTICLE THEREOF

Technical Field of the Invention

The present invention relates to a resin composition blended with a thermoplastic polyester resin not forming an anisotropic molten phase and a liquid-crystal polymer, and a molded article thereof.

Background Art

A liquid-crystal polymer (LCP) capable of forming an anisotropic molten phase is a thermoplastic resin having numerous properties such as high strength, high rigidity, high thermal resistance, mold processability. However, it makes a difference in molding shrinkage and mechanical properties between a molecular chain orientation direction and a transverse direction, and further, it has commercial disadvantages such as high cost.

On the other hand, a thermoplastic polyester resin such as polycarbonate resin (PC), which does not form an anisotropic molten phase, is relatively inexpensive, but there is a disadvantage that it is inferior to LCP in the physical properties such as heat resistance and rigidity.

Especially, since the resin lacks enough rigidity to use for a thin-film housing, it must be thickened on a design. Therefore, there is a limit in its applicability to recent miniaturization/lightening in the fields of electric, electronic, and communication apparatus.

Many trials have, then, been made to make the most of the advantages of LCP and thermoplastic resin not forming an anisotropic molten phase while making up the disadvantages of both by mixing and using them. However, an injection-molded article of a resin composition obtained by simply blending a thermoplastic resin with a small amount of LCP, cannot utilize the LCP's properties such as high strength, high rigidity, thermal resistance and moldability, and results in remarkable deterioration of the mechanical strength. This is because the exhibition of LCP's high mechanical properties and the like originates from a molecular orientation formed under shear and stretch stresses during melt processing. In the resin composition obtained by simply blending a thermoplastic resin and a small amount of LCP, although molecules are particularly oriented in the vicinity of the surface layer of the molded article, most of LCP, other than the surface layer, are only spherically dispersed in a matrix of the thermoplastic resin and provided with no reinforcing effect. Specifically, it is not until LCP takes the form of fibers inside the molded

article that LCP molecules are oriented in the length direction of a fibrous configuration, so that the resin is provided with the reinforcing effect.

Moreover, when the proportion of LCP increases and the thermoplastic resin not forming an anisotropic molten phase is reduced, LCP this time becomes a matrix in which the thermoplastic resin is dispersed as islands. Such the resin composition is of little utility value since the advantages of the thermoplastic resin cannot be utilized.

Accordingly, methods of producing a molded article containing fibrous LCP provided with a reinforcing effect have been proposed as described in JP-A 5-70700 and JP-A 5-112709, wherein a molding material is first prepared beforehand by stretching and extruding LCP and a thermoplastic resin such as PC at a temperature at which both are molten so that LCP is present as fibers having a high aspect ratio, and then, during molding to form the molded article, the molding material is molded at a temperature at which LCP fails to be molten and only the thermoplastic resin such as PC is molten.

In these methods, however, LCP is stretched and extruded in advance to be oriented as fibers. Alternatively, to form the molded article without any preparation, LCP needs to be formed into fibers by applying a considerable shearing force when a mold is filled up with the resin

composition. The former case supposedly results in deteriorated fluidity and limited molding conditions. In the latter case, there are a remarkable influence of the molded article's shape and a possibility of insufficient strength due to partially insufficient fibrous forming.

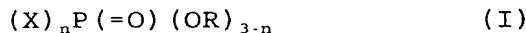
In consideration of the aforementioned problems, a resin composition has been discovered in which, by blending a specific phosphorus compound such as a pentaerythritol-type triester phosphite, it is no longer necessary to extrude LCP in advance so that it is oriented in a fibrous state, LCP is easily modified into a fibrous state to exhibit a reinforcing effect in molding at such a temperature that the LCP is allowed to flow in a sufficient degree, and thereby the mechanical strength, heat resistance, molding-easiness, etc. of the obtained molded article record quite high values closer to those of LCP (JP-A 7-179743). This resin composition is a material having excellent properties as a molding material for a thin-wall molded article. The most distinct characteristic of this resin composition lies in that LCP is easily modified into a fibrous state by injection molding as described above, an extremely high reinforcement effect which has never been observed is obtained, and therefore the resulting molded article has unique properties and can be a thin-wall one especially excellent in mechanical strength.

However, in the resin composition, there arises a problem that the excellent properties of the molded article expected as described above, are unstable due to a variation of melt-kneading conditions in producing the molding material such as the degree of exhaust from a vent and the degree of contact with ambient air. Therefore, an additive which achieves an excellent effect in a more stable manner has been required.

In consideration of the aforementioned problems, the inventors of the present invention have assiduously studied to obtain a resin composition which can stably exhibit excellent properties as a molding material. As a result, they have discovered that, by injection molding a resin composition, in which one or more kinds of compounds selected from phosphorus oxoacid monoesters and diesters has been added to a resin component comprising a liquid crystal polymer and a thermoplastic polyester resin which does not form an anisotropic molten phase, LCP is easily modified into a fibrous state in the molded article and exhibits an extremely high reinforcing effect which has never been observed, and therefore the resulting molded article has unique properties and an excellent mechanical strength, and these characteristics are stably exhibited in the controllable production conditions of the resin composition. Thus, the present invention has been accomplished.

Disclosure of the Invention

That is, the present invention relates to a thermoplastic resin composition, prepared by blending 100 parts by weight in total consisting of 99 to 50 parts by weight of a thermoplastic polyester resin (A) which does not form an anisotropic molten phase and 1 to 50 parts by weight of a liquid crystal polymer (B) capable of forming an anisotropic molten phase, and 0.001 to 2.0 parts by weight of one or more kinds of compounds (C) selected from phosphorus oxoacid monoesters and diesters represented by the following formulae (I) and (II) :



wherein n is 1 or 2; X is a hydrogen atom, a hydroxyl group or a monovalent organic group and, when there are plural X's, they may be the same or different; and R is a monovalent organic group and, when there are plural R's, they may be the same or different.

Namely, a composition comprising (A), (B) and (C) at a ratio as above shown.

The component (C) may include phosphonates represented by the following formula (IV) :



wherein Y is a divalent α,ω -dioxy organic group.

Particularly, a characteristic of the present invention is to provide a molded article excellent in mechanical strength on which fibrously oriented LCP acts as reinforcing component by using the phosphorus oxoacid monoesters and diesters.

Detailed Description of the Invention

The present invention will be described in detail hereinafter.

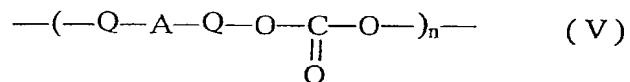
Examples of the thermoplastic polyester resin (A) not forming an anisotropic molten phase which is used in the present invention include polyesters obtained by polycondensation of a dicarboxylic acid compound and a dihydroxy compound, polycondensation of oxycarboxylic acid compounds, or polycondensation of a mixture of these three components, and either homopolyesters or copolyesters can be effective on the present invention. Examples of the dicarboxylic acid compound herein include an aromatic dicarboxylic acid, an alicyclic dicarboxylic acid, an aliphatic dicarboxylic acid, a heterocyclic dicarboxylic acid, a multifunctional carboxylic acid, and ester-forming

derivatives thereof such as alkyl esters and phenyl esters of the above-mentioned carboxylic acids. Specifically, terephthalic acid, isophthalic acid, phthalic acid, naphthalenedicarboxylic acid, biphenyldicarboxylic acid, stilbenedicarboxylic acid, 2,2-(biscarboxyphenyl)propane, biscarboxyphenyl sulfone, cyclohexanedicarboxylic acid, succinic acid, adipic acid, sebacic acid, dodecanoic diacid, dimer acid, pyridinedicarboxylic acid, trimellitic acid, trimesic acid, pyromellitic acid, and ester-forming derivatives thereof are cited. These compounds may be used singly or as a combination of two or more compounds.

Examples of the dihydroxy compounds used herein include ethylene glycol, propane diol, butane diol, hexane diol, neopentyl glycol, cyclohexane diol, cyclohexanediethanol, diethylene glycol, triethylene glycol, hydroquinone, bisphenol A, bisphenol S, biphenol, 2,2-(bishydroxyethoxyphenyl)propane, bishydroxyethoxyphenyl sulfone, 4,4-bis(hydroxyethoxy) biphenyl, dimerdiol, polyethylene glycol, polytetramethylene glycol, trimethylolpropane, pentaerythritol and ester-forming derivatives thereof. They may be used singly or as a combination of two or more compounds. Examples of the oxycarboxylic acid include hydroxybezoic acid, hydroxynaphthoic acid, 4-hydroxy-4'-carboxybiphenyl and ester-forming derivatives thereof. They may be used singly

or as a combination of two or more compounds.

Another example of the thermoplastic polyester resin (A) not forming an anisotropic molten phase which is used in the present invention, is a polycarbonate resin having a repeating unit represented by the following formula (V):



wherein Q is selected from aromatic groups such as naphthylene, phenylene, halogen-substituted phenylene and alkylene group-substituted phenylene; A is selected from -CR₁R₂-, >C=O, -O-, -S-, -SO- and -SO₂-, in which R₁ and R₂ are selected from H, a hydrocarbon group and a group which forms a cycloalkane group with adjacent carbon atoms.

Specifically, the polycarbonate resin is a polycarbonate based polymer produced by reacting one or more kinds of bisphenol compounds with phosgene or diester carbonate. Examples of the bisphenol compounds include: bis(hydroxyaryl)alkanes such as bis(4-hydroxyphenyl)methane, 1,1-bis(4-hydroxyphenyl)ethane, 1,1-bis(4-hydroxyphenyl)propane, 2,2-bis(4-hydroxyphenyl)propane, 2,2-bis(4-hydroxyphenyl)butane, 2,2-bis(4-hydroxyphenyl)pentane, 2,2-bis(4-hydroxyphenyl)octane, 2,2-bis(4-hydroxyphenyl)-3-methylbutane, 2,2-bis(4-hydroxyphenyl)hexane, 1,1-bis(4-hydroxyphenyl)cyclopentane, 1,1-bis(4-

hydroxyphenyl)cyclohexane, bis(4-hydroxy-3-methylphenyl)methane, 1,1-bis(4-hydroxy-3-methylphenyl)ethane, 2,2-bis(4-hydroxy-3-methylphenyl)propane, 2,2-bis(4-hydroxy-3,5-dimethylphenyl)propane, 2,2-bis(4-hydroxy-3-ethylphenyl)propane, 2,2-bis(4-hydroxy-3-t-butylphenyl)propane, 2,2-bis(4-hydroxy-3-bromophenyl)propane, bis(4-hydroxyphenyl)phenylmethane, bis(4-hydroxyphenyl)diphenylmethane, bis(4-hydroxyphenyl)dibenzylmethane, 1,1-bis(4-hydroxyphenyl)-1-phenylpropane, and 2,2,2',2'',-tetrahydro-3,3,3',3''-tetramethyl-1,1'-spirobi-[1H-indene]-6,6'-diol; dihydroxyaryl ketones such as 4,4'-dihydroxydiphenyl ketone, 4,4'-dihydroxy-3,3'-dimethyldiphenyl ketone; dihydroxyaryl ethers such as 4,4'-dihydroxydiphenyl ether, 4,4'-dihydroxy-3,3'-dimethyldiphenyl ether; dihydroxyaryl sulfides such as 4,4'-dihydroxydiphenyl sulfide, 4,4'-dihydroxy-3,3'-dimethyldiphenyl sulfide; dihydroxyaryl sulfones such as 4,4'-dihydroxydiphenyl sulfone, 4,4'-dihydroxy-3,3'-dimethyldiphenyl sulfone; dihydroxyaryl sulfoxides such as 4,4'-dihydroxydiphenyl sulfoxide, 4,4'-dihydroxy-3,3'-dimethyldiphenyl sulfoxide.

Among them, one or more kinds of resins selected from a polycarbonate resin, a polyalkyleneterephthalate resin and a polyarylate resin is especially preferably employed as the

thermoplastic polyester resin (A) not forming an anisotropic molten phase which is used in the present invention. More preferably selected is one or more kinds of resins selected from a polycarbonate resin and a polyarylate resin, and most preferably, a polycarbonate resin.

The polyalkylene terephthalate resin may be polyethylene terephthalate and/or polybutylene terephthalate resin.

The liquid-crystal polymer (LCP) (B) capable of forming an anisotropic molten phase used in the present invention refers to a melt-processed polymer with the property that it can form an optically anisotropic molten phase. The properties of an anisotropic molten phase can be confirmed by the conventional polarization inspection method using orthogonal polarizers. More specifically, confirmation of anisotropy in a molten phase can be attained by using a Leitz polarization microscope and observing a molten sample mounted on a Leitz hot stage under the nitrogen atmosphere at a magnification of 40 times. The LCP applicable to the present invention exhibits an optical anisotropy wherein a polarized light penetrates even in a static molten phase, when observed between cross polarizers. As the LCP usable in the present invention, aromatic polyester and aromatic polyester amide are preferable, and polyester partially containing these structures in the same

molecular chain is also preferable.

Examples of the components or monomer groups constituting such LCP include:

- (1) an aromatic hydroxycarboxylic acid, an aromatic aminocarboxylic acid and derivatives thereof;
- (2) an aromatic dicarboxylic acid, an alicyclic dicarboxylic acid and derivatives thereof;
- (3) an aromatic diol, an alicyclic diol, an aliphatic diol and derivatives thereof; and
- (4) an aromatic hydroxyamine, an aromatic diamine and derivatives thereof. By using these components, the LCP is constituted, for example, of solely (1), or a combination of, for example, (2) and (3), (2) and (4), (1), (2) and (3), (1), (2) and (4), and (1), (2), (3) and (4).

Examples of the aromatic hydroxycarboxylic acid and the aromatic aminocarboxylic acid (1) include 4-hydroxybenzoic acid, 3-hydroxybenzoic acid, 6-hydroxy-2-naphthoic acid, 6-hydroxy-1-naphthoic acid, 4-(4-hydroxyphenyl)benzoic acid, 3-methyl-4-hydroxybenzoic acid, 3,5-dimethyl-4-hydroxybenzoic acid, 2,6-dimethyl-4-hydroxybenzoic acid, 3-methoxy-4-hydroxybenzoic acid, 3,5-dimethoxy-4-hydroxybenzoic acid, 3-phenyl-4-hydroxybenzoic acid, 6-hydroxy-5-methyl-2-naphthoic acid, 6-hydroxy-5-methoxy-2-naphthoic acid, 2-chloro-4-hydroxybenzoic acid, 3-chloro-4-hydroxybenzoic acid, 3,5-dichloro-4-hydroxybenzoic

acid, 2,5-dichloro-4-hydroxybenzoic acid, 2,6-dichloro-4-hydroxybenzoic acid, 3-bromo-4-hydroxybenzoic acid, 6-hydroxy-5-chloro-2-naphthoic acid, 6-hydroxy-7-chloro-2-naphthoic acid, 4-aminobenzoic acid, 3-aminobenzoic acid, 6-amino-2-naphthoic acid and the like.

Examples of the aromatic dicarboxylic acid and the alicyclic dicarboxylic acid (2) include terephthalic acid, isophthalic acid, 2,6-naphthalenedicarboxylic acid, 2,7-naphthalenedicarboxylic acid, 1,4-naphthalenedicarboxylic acid, 1,5-naphthalenedicarboxylic acid, 4,4'-diphenylcarboxylic acid, 3,4'-diphenylcarboxylic acid, 3,3'-diphenylcarboxylic acid, 4,4"-terphenyldicarboxylic acid, diphenylether-4,4'-dicarboxylic acid, dipenoxyethane-4,4'-dicarboxylic acid, methylterephthalic acid, dimethylterephthalic acid, phenylterephthalic acid, methoxyterephthalic acid, chloroterephthalic acid, dichloroterephthalic acid, bromoterephthalic acid, 1,4-cyclohexanedicarboxylic acid, 1,3-cyclohexanedicarboxylic acid, [2.2.2]bicyclooctanedicarboxylic acid.

Examples of the aromatic diol, alicyclic diol and aliphatic diol (3) include hydroquinone, resorcinol, 2,6-naphthalene diol, 1,5-naphthalene diol, 2,7-naphthalene diol, 4,4'-dihydroxydiphenyl, 3,3'-dihydroxydiphenyl, 3,4'-dihydroxydiphenyl, 4,4"-dihydroxyterphenyl, 4,4'-dihydroxydiphenyl ether, 2,2-bis(4-hydroxyphenyl)propane,

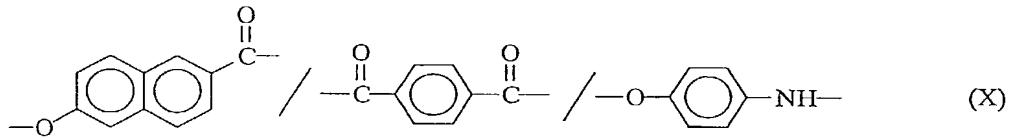
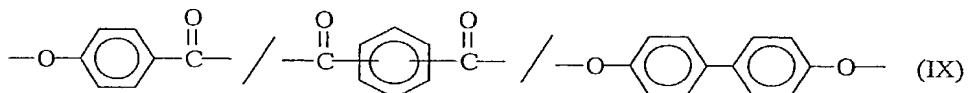
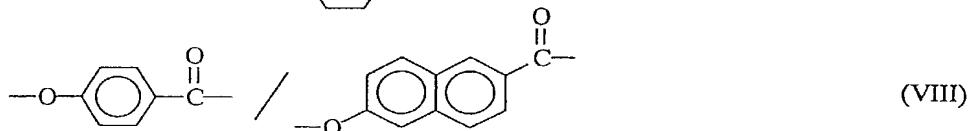
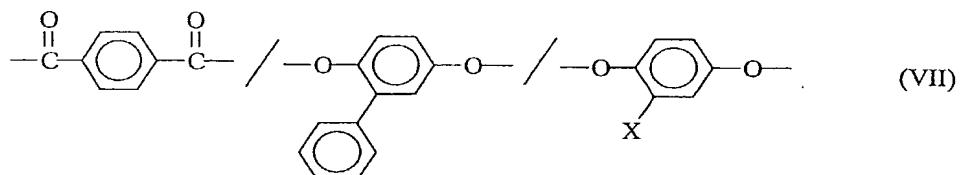
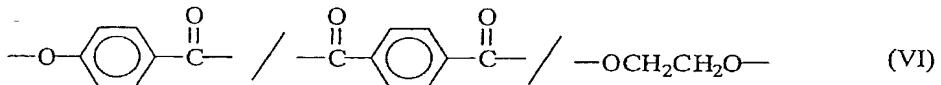
4,4'-dihydroxyphenyl ketone, 4,4'-dihydroxydiphenyl sulfide,
4,4'-dihydroxydiphenyl sulfoxide, N-(4-hydroxyphenyl)-3-
hydroxyphthalimide, chlorohydroquinone, methylhydroquinone,
2,5-dimethylhydroquinone, t-butylhydroquinone, 2,5-di-t-
butylhydroquinone, phenylhydroquinone, methoxyhydroquinone,
chlorohydroquinone, 4-methylresorcinol, 4-chlororesorcinol,
3,3'-dimethyl-4,4'-dihydroxydiphenyl, 1,4-cyclohexanediol,
1,3-cyclohexanediol, 1,4-cyclohexanedimethanol, 1,3-
cyclohexanedimethanol, ethylene glycol, 1,3-propanediol,
1,4-butanediol.

Examples of the aromatic hydroxyamine and aromatic diamine (4) include 4-aminophenol, N-methyl-4-aminophenol, 1,4-phenylenediamine, N-methyl-1,4-phenylenediamine, N,N'-dimethyl-1,4-phenylenediamine, 3-aminophenol, 3-methyl-4-aminophenol, 2-chloro-4-aminophenol, 4-amino-1-naphthol, 4-amino-4'-hydroxydiphenyl, 2,6-diaminonaphthalene, 4,4'-diaminodiphenyl, 4,4'-diaminodiphenylmethane.

In addition, a molecular weight adjusting agent may be added to the above components, if necessary. Examples of the molecular weight adjusting agent include monofunctional components such as benzoic acid, phenol and 4-phenylphenol.

Among the components described above, more preferably examples are those which contain as essential components one or more kinds of compounds selected from naphthalene compounds, biphenyl compounds and phenylene compounds.

Typical examples of such liquid crystal polymers include the followings:

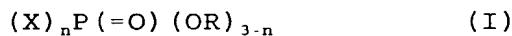


In the present invention, the ratio of the thermoplastic resin (A) not forming an anisotropic molten phase to the liquid crystal polymer (B) [(A)/(B)] is 99/1 to 50/50, preferably 99/1 to 80/20. When (A)/(B) is larger than 99/1, the fiberized LCP does not exhibit substantial reinforcing effects and an advantage cannot be obtained over the properties of the thermoplastic resin (A) contained only. On the other hand, when (A)/(B) is smaller than 50/50, since the matrix is the liquid crystal polymer, the properties of the thermoplastic polyester resin cannot be utilized.

undesirably.

The effect of blending the compound (C) of the present invention is in that the compound (C) is highly effective as a dispersing assistant for micro-dispersing LCP (B) in the matrix phase and that the mechanical properties of the product are distinctively improved. In addition, this effect is stable as compared with that of the conventional phosphorus compound (triester phosphite).

The phosphorus oxoacid monoesters and diesters (C) used in the present invention are represented by the following formulae (I) and (II):



wherein n is 1 or 2; X is a hydrogen atom, a hydroxyl group or a monovalent organic group and, when there are plural X's, they may be the same or different; and R is a monovalent organic group and, when there are plural R's, they may be the same or different.

Generally, phosphonate compounds, phosphinate compounds, phosphonite compounds, phosphinite compounds and organic phosphorus compounds containing these phosphorus components in the molecule are applicable.

Specific examples of the phosphonate compound include dimethylphosphonate, diethylphosphonate, dibutylphosphonate, di(ethylhexyl)phophonate, didecylphosphonate,

dipalmitylphosphonate, distearylphosphonate,
dilaurylphosphonate, diphenylphosphonate,
dibenzylphosphonate, ditoluylphosphonate,
di(nonylphenyl)phosphonate, dioleylphosphonate,
dimethylmethylphosphonate, diethylmethylphosphonate,
di(ethylhexyl)methylphosphonate, dipalmitylmethylphosphonate,
distearyl methylphosphonate, dilaurylmethylphosphonate,
diphenylmethylphosphonate, dimethylphenylphosphonate,
diethylphenylphosphonate, di(ethylhexyl)phenylphosphonate,
dipalmitylphenylphosphonate, distearylphenylphosphonate,
dilaurylphenylphosphonate, diphenylphenylphosphonate, and
dibenzylphenylphosphonate.

Specific examples of the phosphinate compound include
methylphosphinate, ethylphosphinate, butylphosphinate,
ethylhexylphosphinate, palmitylphosphinate,
stearylphosphinate, laurylphosphinate, phenylphosphinate,
benzylphosphinate, toluylphosphinate, nonylphenylphosphinate,
oleylphosphinate, ethylmethylphosphinate,
ethyldimethylphosphinate,
(ethylhexyl)methylphosphinate,
(ethylhexyl)dimethylphosphinate,
palmitylmethylphosphinate, palmityldimethylphosphinate,
stearyl methylphosphinate, stearyl dimethylphosphinate,
laurylmethylphosphinate, lauryldimethylphosphinate,
phenylmethylphosphinate, ethylphenylphosphinate,

(ethylhexyl)phenylphosphinate, palmitylphenylphosphinate, stearylphenylphosphinate, stearyl diphenylphosphinate, laurylphenylphosphinate, lauryl diphenylphosphinate, phenylphenylphosphinate, and benzylphenylphosphinate.

Specific examples of the phosphonite compound include dimethylphosphonite, diethylphosphonite, dibutylphosphonite, di(ethylhexyl)phosphonite, didecylphosphonite, dipalmitylphosphonite, distearylphosphonite, dilaurylphosphonite, diphenylphosphonite, dibenzylphosphonite, ditoluylphosphonite, di(nonylphenyl)phosphonite, dioleylphosphonite, dimethylmethylphosphonite, diethylmethylphosphonite, di(ethylhexyl)methylphosphonite, dipalmitylmethylphosphonite, distearyl methylphosphonite, dilaurylmethylphosphonite, diphenylmethylphosphonite, dimethylphenylphosphonite, diethylphenylphosphonite, di(ethylhexyl)phenylphosphonite, dipalmitylphenylphosphonite, distearylphenylphosphonite, dilaurylphenylphosphonite, diphenylphenylphosphonite, and dibenzylphenylphosphonite.

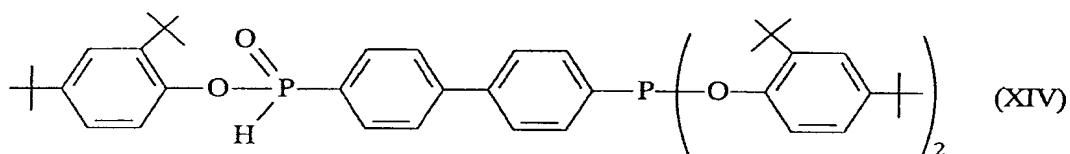
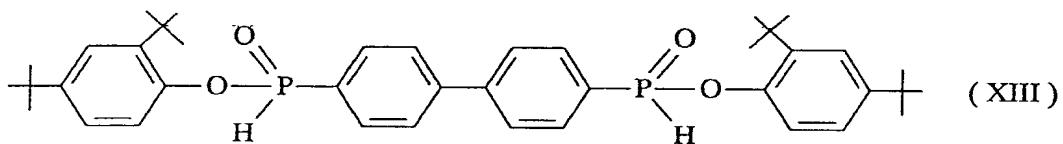
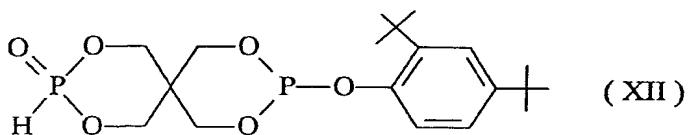
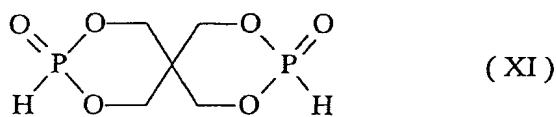
Specific examples of the phosphinite compound include methylphosphinite, ethylphosphinite, butylphosphinite, ethylhexylphosphinite, palmitylphosphinite, stearylphosphinite, laurylphosphinite, phenylphosphinite, benzylphosphinite, toluylphosphinite, nonylphenylphosphinite, oleylphosphinite, ethylmethylphosphinite,

ethyldimethylphosphinite, (ethylhexyl)methylphosphinite,
(ethylhexyl)dimethylphosphinite, palmitylmethylphosphinite,
palmityldimethylphosphinite, stearyl methylphosphinite,
stearyldimethylphosphinite, laurylmethylphosphinite,
lauryldimethylphosphinite, phenylmethylphosphinite,
ethylphenylphosphinite, (ethylhexyl)phenylphosphinite,
palmitylphenylphosphinite, stearylphenylphosphinite,
stearyldiphenylphosphinite, laurylphenylphosphinite,
lauryldiphenylphosphinite, phenylphenylphosphinite, and
benzylphenylphosphinite. Among them, the phosphonic acid
ester represented by the formula (III) is especially
preferable:



wherein m is 0 or 1 and R is a monovalent organic group.

As the phosphorus compound (C), an organic phosphorus compound which contains the aforementioned components such as phosphonates, phosphinates, phosphonites and phosphinites in the molecule thereof may also be used. Specific examples include the followings:



The amount of the specific phosphorus compound to be blended in the present invention is preferably 0.001-2.0 parts by weight, and more preferably 0.01-0.5 part by weight to 100 parts by weight in total of the components (A) and (B). When the amount is less than 0.001 part by weight, the effect of modifying the liquid crystal polymer into a fibrous state during the molding process is small. When the amount exceeds 2.0 parts by weight, the physical properties of the material may deteriorate.

Further, a thermoplastic resin which does not form an anisotropic molten phase other than the compounds (A) and (B) may be blended in an amount of 1-90 parts by weight to

100 parts by weight in total of the compounds (A) and (B) in the present invention. Examples of such an additional thermoplastic resin include polyethylene, polypropylene, ethylene-propylene copolymer, ethylene-vinyl acetate copolymer, polyamide, polyacetal, styrene-based resins such as polystyrene, styrene-butadiene copolymer, styrene-butadiene-acrylonitrile copolymer and styrene-acrylonitrile copolymer, polyurethane, fluororesin, polyphenyleneoxide, polyphenylenesulfide, polybutadiene, butyl rubber, silicone resin, olefin-based thermoplastic elastomer, styrene-based thermoplastic elastomer, urethane-based thermoplastic elastomer, polyester-based thermoplastic elastomer, polyamide-based thermoplastic elastomer, polyether-based thermoplastic elastomer, multi-layer graft copolymer mainly containing polyacrylate and modified compounds thereof. Among them, preferred are styrene-based resin and polyphenyleneoxide which show relatively good mutual solubility to a polyester resin.

Furthermore, it is desirable to blend one or more kinds of silane compounds selected from vinylalkoxysilane, aminoalkoxysilane and mercaptoalkoxysilane in the present invention. By blending this component, an injection-molded article that shows little peeling on the surface thereof can be obtained.

Additionally, the molded article of the blend

composition of the present invention can be blended with various types of fibrous, powder and plate inorganic fillers according to the purposes of application. Examples of fibrous fillers include inorganic fibrous substances such as glass fibers, asbestos fibers, silica fibers, silica/alumina fibers, alumina fibers, zirconia fibers, boron nitride fibers, silicon nitride fibers, boron fibers, potassium titanate fibers, and further, fibrous metals, e.g., stainless, aluminum, titanate, copper and brass. Examples of powdery fillers include silicate such as carbon black, graphite, silica, quartz powders, glass beads, milled glass fibers, glass balloons, glass powders, calcium silicate, aluminum silicate, kaoline, talc, clay, diatom earth and wollastonite, metal oxide such as iron oxide, titanium oxide, zinc oxide, antimony trioxide and alumina, metal carbonate such as calcium carbonate and magnesium carbonate, metal sulfate such as calcium sulfate and barium sulfate, and further, ferrite, silicon carbide, silicon nitride, boron nitride, and other various metal powders. Examples of tabular fillers include mica, glass flakes, various metal foils and the like. One or two or more types of these inorganic fillers can be used together. Moreover, the inorganic fillers used in the present invention can be used in combination with a known surface treatment agent in accordance with desired physical properties. For example,

functional compounds such as epoxy compounds, isocyanate compounds, titanate compounds and silane compounds are cited. Preferably, treatment is performed with the compounds other than amino compounds, such as epoxy compounds and polyamide compounds. These fillers may be used after surface treatment, or added at the same time of material preparation. Herein, the amount of the inorganic fillers to be blended is preferably 1 to 100 parts by weight based on 100 parts by weight of the total amount of (A) and (B).

Moreover, the molded article may be flame-retarded by blending a flame retardant. As the flame retardant, organic halogen compounds and the like are used, but especially aromatic bromine compounds are preferable. Additionally, as a flame retardant assistant, metal oxide and hydroxide such as antimony trioxide, antimony halide, aluminum hydroxide and magnesium hydroxide are preferably used.

In this resin composition, LCP is preferably present as fibers having an average aspect ratio of 5 or more inside the molded article, especially preferably having the average aspect ratio of 8 or more. When the average aspect ratio is less than 5, a high strength and a high elasticity modulus as the characteristics of this resin composition cannot be obtained, and especially, a thin-film molded article for miniaturization and lightening cannot obtain a sufficient rigidity.

The composition of the present invention can generally be prepared by the equipment and methods used in preparing a synthetic resin composition. For example, there is a method of mixing necessary components, using a uniaxial or twin-screw extruder, kneading/extruding to prepare molding pellets and, subsequently, molding; a method of once preparing pellets having different compositions from one another, mixing a specific amount of the pellets to be subjected to molding, and obtaining a molded article having an intended composition; or the like. Namely, any method of preparing the composition before molding may be used, since LCP is formed into fibers during molding in the present invention. Additionally, LCP contained in the composition is preferably molded at a temperature at which LCP flows by a shearing force during molding, especially at a temperature of a melting point of LCP or higher. When the temperature is the LCP's melting point or higher, the LCP's property of easy flow by the shearing force is utilized, and LCP can easily be formed into fibers by the shearing force.

Examples

Hereinafter, the present invention will be described in more detail with reference to the following examples, but the present invention is not limited to the examples.

Example 1

0.1 part by weight of dioleylphosphonate (manufactured by Johoku Kagaku Kogyo Co., Ltd.) was added to a resin component containing 80 parts by weight of a polycarbonate resin (Upiron S3000, manufactured by Mitsubishi Gas Chemical Co., Ltd.) and 20 parts by weight of a liquid crystal polymer (A950, manufactured by Polyplastics Co., Ltd.). The mixture was melt-kneaded at a resin temperature 290 °C in a 30 mm twin-screw extruder, and pelletized to obtain the aimed resin composition.

In the extrusion process, the aimed resin composition was prepared with removing the volatile components via a vent by a pressure-reducing operation, while care was taken so that air should not be mixed into the kneaded materials and oxidize them.

Then, the obtained pellets were formed by injection molding into a test piece having thickness of 0.8 mm, width of 12.7 mm and length of 131 mm at a resin temperature 290 °C.

The bending strength and flexural modulus of the test piece were measured according to ASTM D 790.

The test piece was cut in the flow direction and the surface of the section was mirror-polished. When the polished surface was observed by an electronic microscope to evaluate the condition of the surface, it was observed that

the liquid crystal polymer formed a fibrous structure in the polycarbonate resin. 50 fibers of the liquid crystal polymer in a fibrous state were arbitrarily chosen and thickness/diameter thereof were measured to calculate the average values of thickness/diameter. With respect to the length of the fibers, the length which could be observed on the surface was measured.

Comparative Example 1

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 1 except that dioleylphosphonate was not added. Further, the test piece was cut in the flow direction and the surface of the section was mirror-polished. When the polished surface was observed by an electronic microscope to evaluate the condition of the surface, a structure was observed in which the liquid crystal polymer was dispersed insularly in the polycarbonate resin.

Examples 2-5, Comparative Examples 2-3

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 1 except that a phosphorus compound shown in Table 1 was added in an amount shown in Table 1 in place of dioleylphosphonate.

Example 6

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 1 except that the blending ratio of the polycarbonate resin to the liquid crystal polymer was changed as shown in Table 1.

Example 7

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 1 except that the polyarylate resin (U-Polymer, U-1000 manufactured by Unichika Co., Ltd.) was used in place of the polycarbonate resin.

Comparative Example 4

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 7 except that dioleylphosphonate was not added.

Example 8

0.1 part by weight of dioleylphosphonate and 30 parts by weight of glass fiber (chopped strand having a fiber diameter of 13 μm and a fiber length of 5 mm) were added to a resin component containing 50 parts by weight of the polycarbonate resin and 20 parts by weight of the liquid crystal polymer. Then, a test piece was molded and physical

properties thereof were evaluated in the same manner as other Examples.

Example 9

0.1 part by weight of dioleylphosphonate, 30 parts by weight of glass fiber (chopped strand having a fiber diameter of 13 μm and a fiber length of 5 mm) and 10 parts by weight of fine mica having the average particle diameter of 18 μm and the average aspect ratio of 20 were added to a resin component containing 40 parts by weight of the polycarbonate resin and 20 parts by weight of the liquid crystal polymer. Then, a test piece was molded and physical properties thereof were evaluated in the same manner as other Examples (except that a 44 mm twin-screw extruder was used).

Comparative Example 5

A test piece was molded and physical properties thereof were evaluated in the same manner as Example 9 except that dioleylphosphonate was not added. In this test piece, the dispersed state of the liquid crystal copolymer was not observed.

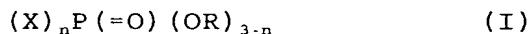
The results of evaluation described above are shown in Table 1.

Table 1

	Composition (parts by weight)										Evaluation			
	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7	Ex. 8	Ex. 9	Com. Ex. 1	Com. Ex. 2	Com. Ex. 3	Com. Ex. 4	Com. Ex. 5
(A) Polycarbonate resin	80	80	80	80	80	60	50	40	80	80	80	80	80	40
(A) Polyarylate resin						80								80
(B) Liquid crystal polymer (A950)	20	20	20	20	20	40	20	20	20	20	20	20	20	20
Dioleylphosphonate	0.1					0.1	0.1	0.1	0.1					
DiOctadecylphosphonate	0.1	0.3												
Dinonylphenylphosphonate			0.1											
(C) Mixture of monostearylphosphate/ destearylphosphate in 44/55				0.1										
Bis(2,6-di-t-butyl-4-methylphenyl) pentaerythritoldiphosphite										0.1				
Tridecylphosphate												0.1		
Glass fiber									30	30				30
Mica										10				10
Bending strength MPa	145	140	138	143	135	168	195	240	224	95	110	93	120	123
Flexial modulus MPa	6070	6080	6010	6100	5800	8350	6550	14900	16300	2880	4500	2850	2780	11000
Dispersing state of liquid crystal polymer	fibrous	fibrous	fibrous	fibrous	fibrous	fibrous	fibrous	fibrous	fibrous	insular	fibrous	insular	insular	—
Average aspect ratio of liquid crystal polymer	9.0	7.2	7.3	8.6	6.5	6.4	5.8	>9.0	1.5	4.2	1.3	1.1	—	

Claims

1. A thermoplastic resin composition comprising 100 parts by weight in total consisting of 99 to 50 parts by weight of a thermoplastic polyester resin (A) which does not form an anisotropic molten phase and 1 to 50 parts by weight of a liquid crystal polymer (B) capable of forming an anisotropic molten phase, and 0.001 to 2.0 parts by weight of one or more kinds of compounds (C) selected from phosphorus oxoacid monoesters and diesters represented by the following formulae (I) and (II):



wherein n is 1 or 2; X is a hydrogen atom, a hydroxyl group or a monovalent organic group and, when there are plural X's, they may be the same or different; and R is a monovalent organic group and, when there are plural R's, they may be the same or different.

2. The composition according to claim 1, wherein the thermoplastic polyester resin (A) not forming an anisotropic molten phase includes one or more kinds of resins selected from polycarbonate resin, polyalkylene terephthalate resin and polyarylate resin.

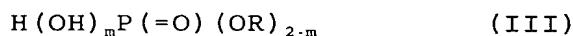
3. The composition according to claim 1, wherein the thermoplastic polyester resin (A) not forming an anisotropic

molten phase includes one or more kinds of resins selected from polycarbonate resin and polyarylate resin.

4. The composition according to claim 1, wherein the thermoplastic polyester resin (A) not forming an anisotropic molten phase is polycarbonate resin.

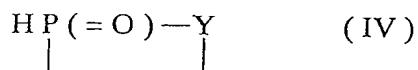
5. The composition according to claim 2, wherein the polyalkylene terephthalate resin includes polyethylene terephthalate and/or polybutylene terephthalate resin.

6. The composition according to any of claims 1 to 4, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (III):



wherein m is 0 or 1 and R is a monovalent organic group.

7. The composition according to any of claims 1 to 5, wherein the phosphorus oxoacid monoester and diester (C) are phosphonates represented by the following formula (IV):



wherein Y is a divalent α,ω -dioxy organic group.

8. The composition according to any of claims 1 to 7, which further contains a thermoplastic resin not forming an anisotropic molten phase, except for (A) and (B), in an amount of 1 to 90 parts by weight to 100 parts by weight of the total amount of (A) and (B).

9. The composition according to any of claims 1 to 8, which further contains an inorganic filler in an amount of 1 to 100 parts by weight to 100 parts by weight of the total amount of (A) and (B).

10. A molded article prepared by molding the composition according to any of claims 1 to 9.

11. An injection molded article, wherein the liquid crystal polymer (B) capable of forming an anisotropic molten phase is present in the state of fibers having an average aspect ratio of 5 or more in a matrix of the thermoplastic polyester resin (A) not forming an anisotropic molten phase as a result of an injection molding of the composition according to any of claims 1 to 9.

Abstract

To provide a resin composition, in which a liquid crystal polymer is made into fiber in a molded article to exhibit an extremely high reinforcing effect which has not been available yet, and from which a molded article having an excellent mechanical strength can be manufactured in a stable manner. That is, a thermoplastic resin composition, wherein 100 parts by weight in total consisting of 99-50 parts by weight of a thermoplastic polyester resin (A) not forming an anisotropic molten phase and 1-50 parts by weight of a liquid crystal polymer (B) capable of forming an anisotropic molten phase is blended with 0.001-2.0 parts by weight of one or more kinds of compounds (C) selected from phosphorus oxoacid monoester and diester represented by the following formulae (I) and (II):



wherein n is 1 or 2; X is a hydrogen atom, a hydroxyl group or a monovalent organic group and, when there are plural X's, they may be the same or different; and R is a monovalent organic group and, when there are plural R's, they may be the same or different.

**COMBINED DECLARATION AND POWER OF ATTORNEY
FOR UTILITY PATENT APPLICATION**

Attorney's Docket No.
009760-015

As a below-named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name;

I BELIEVE I AM THE ORIGINAL, FIRST AND SOLE INVENTOR (if only one name is listed below) OR AN ORIGINAL, FIRST AND JOINT INVENTOR (if more than one name is listed below) OF THE SUBJECT MATTER WHICH IS CLAIMED AND FOR WHICH A PATENT IS SOUGHT ON THE INVENTION ENTITLED:

THERMOPLASTIC RESIN COMPOSITION AND MOLDED ARTICLE THEREOF

the specification of which

(check one)

is attached hereto;
 was filed on July 12, 2000 as
Application No. PCT/JP00/04671
and was amended on _____;
(if applicable)

I HAVE REVIEWED AND UNDERSTAND THE CONTENTS OF THE ABOVE-IDENTIFIED SPECIFICATION, INCLUDING THE CLAIMS, AS AMENDED BY ANY AMENDMENT REFERRED TO ABOVE;

I ACKNOWLEDGE THE DUTY TO DISCLOSE TO THE OFFICE ALL INFORMATION KNOWN TO ME TO BE MATERIAL TO PATENTABILITY AS DEFINED IN TITLE 37, CODE OF FEDERAL REGULATIONS, Sec. 1.56 (as amended effective March 16, 1992);

I do not know and do not believe the said invention was ever known or used in the United States of America before my or our invention thereof, or patented or described in any printed publication in any country before my or our invention thereof or more than one year prior to said application; that said invention was not in public use or on sale in the United States of America more than one year prior to said application; that said invention has not been patented or made the subject of an inventor's certificate issued before the date of said application in any country foreign to the United States of America on any application filed by me or my legal representatives or assigns more than twelve months prior to said application;

I hereby claim foreign priority benefits under Title 35, United States Code Sec. 119 and/or Sec. 365 of any foreign application(s) for patent or inventor's certificate as indicated below and have also identified below any foreign application for patent or inventor's certificate on this invention having a filing date before that of the application(s) on which priority is claimed:

COMBINED DECLARATION AND POWER OF ATTORNEY		Attorney's Docket No. 009760-015
---	--	--

COUNTRY/INTERNATIONAL	APPLICATION NUMBER	DATE OF FILING (day, month, year)	PRIORITY CLAIMED
Japan	11-202839	16 July 1999	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>
			YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>

I hereby appoint the following attorneys and agent(s) to prosecute said application and to transact all business in the Patent and Trademark Office connected therewith and to file, prosecute and to transact all business in connection with international applications directed to said invention:

William L. Mathis	17,337	Eric H. Weisblatt	30,505	Brace T. Wieder	33,815
Robert S. Swecker	19,885	James W. Peterson	26,057	Todd R. Walters	34,040
Platon N. Mandros	22,124	Teresa Staneck Rea	30,427	Ronni S. Jillions	31,979
Benton S. Duffett, Jr.	22,030	Robert E. Krebs	25,885	Harold R. Brown III	36,341
Norman H. Stepno	22,716	William C. Rowland	30,888	Allen R. Baum	36,086
Ronald L. Grudziecki	24,970	T. Gene Dillahunty	25,423	Brian P. O'Shaughnessy	32,747
Frederick G. Michaud, Jr.	26,003	Patrick C. Keane	32,858	Kenneth B. Leffler	36,075
Alan E. Kopecki	25,813	B. Jefferson Boggs, Jr.	32,344	Fred W. Hathaway	32,236
Regis E. Sluter	26,999	William H. Benz	25,952	Wendi L. Weinstein	34,455
Samuel C. Miller, III	27,360	Peter K. Skiff	31,917	Mary Ann Dillahunty	34,576
Robert G. Mukai	28,531	Richard J. McGrath	29,195		
George A. Hovanec, Jr.	28,223	Matthew L. Schneider	32,814		
James A. LaBarre	28,632	Michael G. Savage	32,596		
E. Joseph Gess	28,510	Gerald F. Swiss	30,113		
R. Danny Huntington	27,903	Charles F. Wieland III	33,096		

21839

and: none

Address all correspondence to:



21839

Benton S. Duffett, Jr.
BURNS, DOANE, SWECKER & MATHIS, L.L.P.
P.O. Box 1404
Alexandria, Virginia 22313-1404

Address all telephone calls to: Benton S. Duffett, Jr. at (703) 836-6620.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

FULL NAME OF SOLE OR FIRST INVENTOR Keiichi Kanaka	SIGNATURE <i>Keiichi Kanaka</i>	DATE Nov. 14, 2001
RESIDENCE Shizuoka, Japan	CITIZENSHIP Japan	
POST OFFICE ADDRESS c/o Polyplastics Co., Ltd. 973, Miyajima, Fuji-shi, Shizuoka, Japan <i>JPX</i>		
FULL NAME OF SECOND JOINT INVENTOR, IF ANY Toshio Shiwaku	SIGNATURE <i>[Signature]</i>	DATE Nov. 14, 2001
RESIDENCE Shizuoka, Japan <i>JPX</i>	CITIZENSHIP Japan	
POST OFFICE ADDRESS c/o Polyplastics Co., Ltd. 973, Miyajima, Fuji-shi, Shizuoka, Japan		

COMBINED DECLARATION AND POWER OF ATTORNEY		Attorney's Docket No.
		009760-015
300 FULL NAME OF THIRD JOINT INVENTOR, IF ANY Mineo Ohtake RESIDENCE Shizuoka, Japan <i>JPK</i>		SIGNATURE <i>Mineo Ohtake</i> DATE Nov. 14, 2001
POST OFFICE ADDRESS c/o Polyplastics Co., Ltd. 973, Miyajima, Fuji-shi, Shizuoka, Japan		CITIZENSHIP Japan
FULL NAME OF FOURTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF FIFTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF SIXTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF SEVENTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF EIGHTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF NINTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		
FULL NAME OF TENTH JOINT INVENTOR, IF ANY		SIGNATURE
RESIDENCE		CITIZENSHIP
POST OFFICE ADDRESS		